

Date:  
User:Monday, 3/6/2006 1:55:52 PM  
Kim Johnston

## Process Sheet

|                       |   |                  |   |
|-----------------------|---|------------------|---|
| Customer              | : CU-DAR001 Dart Helicopters Services       | Drawing Name     | : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE |
| Job Number            | : 26080                                     |                  |   |
| Estimate Number       | : 10834                                     | Part Number      | : D29332                                |
| P.O. Number           | : <i>N/A</i>                                | Drawing Number   | : D2933 REV B                           |
| This Issue            | : 3/6/2006                                  | Project Number   | : N/A                                   |
| Prsht Rev.            | : NC  | Drawing Revision | : B                                     |
| First Issue           | : <i>N/A</i>                                | Material         | : <i>N/A</i>                            |
| Previous Run          | : 25377                                     | Due Date         | : 3/31/2006                             |
| Written By            | : <i>See comment below</i>                  | Qty:             | 4 Um: Each                              |
| Checked & Approved By | : <i>06.03.06</i>                           |                  |   |
| Comment               | : Est: B 00.06.26 New DWG rev (mpp 2069) EC |                  |   |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |          |                     |
|-----|----------|---------------------|
| 1.0 | D610f001 | 7075-T7351 2X6X6.25 |
|-----|----------|---------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Issue material from stock: 7075-T7351 QQ-A-250/12  
 Cut Size 2.0 x 6.25 X 6.00  
 Grain Along Long 6.00 Length  
 Batch No: *M24890*

|     |       |                                |
|-----|-------|--------------------------------|
| 2.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1  
 Program part number and batch number.  
 1-Inspect part number and batch number are programmed correctly.  
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet  
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet  
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet  
 5-Deburr

*J.L 06.04.21 (H)*

|     |               |                              |
|-----|---------------|------------------------------|
| 3.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE |
|-----|---------------|------------------------------|



Comment: CONVENTIONAL MILLING MACHINE  
 Machine Keyway and inspect per attached dimension sheet

*J.L 06.04.21 (H)*

|     |     |                              |
|-----|-----|------------------------------|
| 4.0 | QC1 | INSPECT ALL DIM TO DIM SHEET |
|-----|-----|------------------------------|



Comment: INSPECT ALL DIM TO DIM SHEET

*J.L 06.04.21 (H)*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: SD Date: 06/04/28  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Monday, 3/6/2006 1:55:52 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 26080

Part Number: D29332

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/04/21

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06/04/22 (4)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

TX 06/04/25 (4)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PD 06/04/27 (4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SJ475

AB 06/04/27 (4)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/04/28 (4)

Job Completion



CY 06/04/28

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|   |                     |             |
|---|---------------------|-------------|
| <b>DART AEROSPACE LTD</b>                           | <b>Work Order:</b>  | 26080       |
| <b>Description:</b> 206 Saddle, Inboard, Right side | <b>Part Number:</b> | D2933-2     |
| <b>Inspection Dwg:</b> D2933 Rev. B                 |                     | Page 1 of 1 |

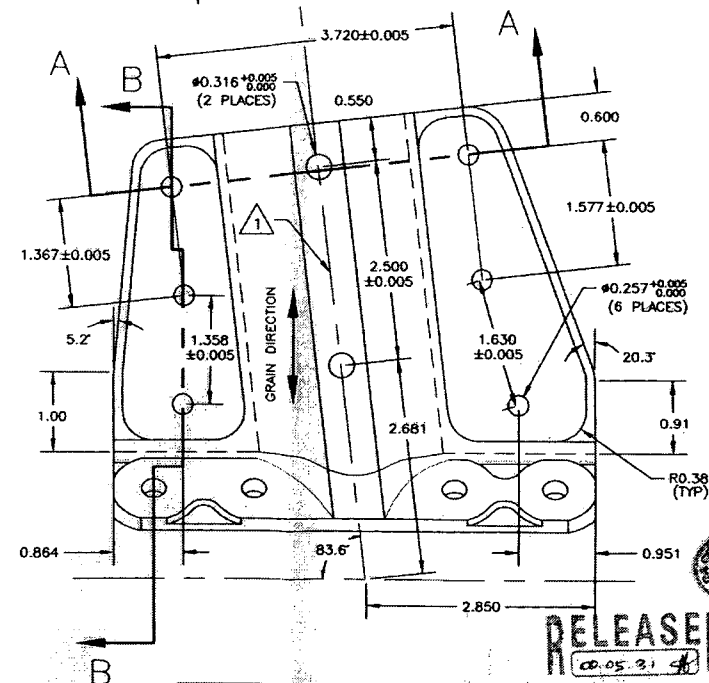
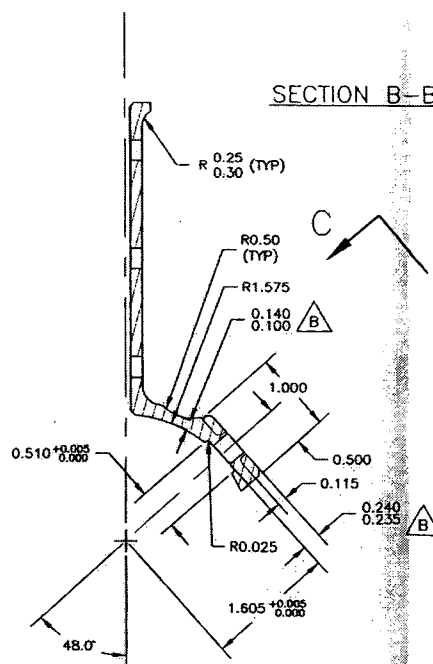
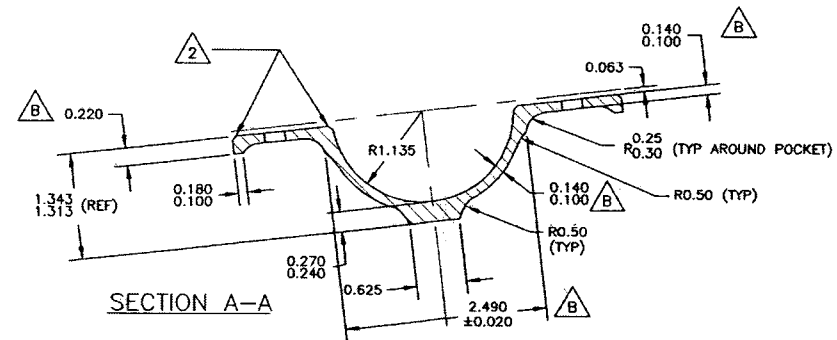
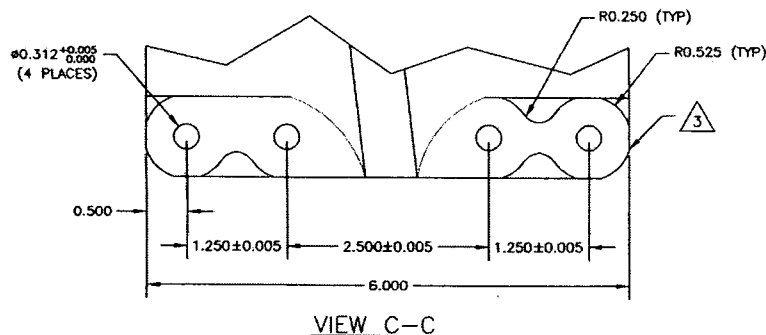
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

|               |       |       |                | Recorded Actual Dimensions |       |       |       | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                          | 2     | 3     | 4     |    |      |
| A             | 0.100 | 0.140 |                | .125                       | .124  | .123  | .122  |    |      |
| B             | 0.100 | 0.140 |                | .125                       | .123  | .123  | .122  |    |      |
| C             | 0.100 | 0.140 |                | .123                       | .119  | .118  | .123  |    |      |
| D             | 0.210 | 0.230 |                | .223                       | .221  | .221  | .220  |    |      |
| E             | 1.245 | 1.255 |                | 1.250                      | 1.250 | 1.250 | 1.250 |    |      |
| F             | 1.245 | 1.255 |                | 1.250                      | 1.249 | 1.250 | 1.250 |    |      |
| G             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.499 | 2.501 |    |      |
| H             | 0.510 | 0.515 |                | .514                       | .514  | .514  | .514  |    |      |
| I             | 1.572 | 1.582 |                | 1.577                      | 1.577 | 1.576 | 1.576 |    |      |
| J             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.500 | 2.500 |    |      |
| K             | 0.257 | 0.262 | DT8683         | /                          | /     | /     | /     |    |      |
| L             | 0.312 | 0.317 | DT8686         | /                          | /     | /     | /     |    |      |
| M             | 0.235 | 0.240 |                | .239                       | .238  | .240  | .239  |    |      |
| N             | 0.100 | 0.140 |                | .118                       | .121  | .117  | .118  |    |      |
| O             | 0.540 | 0.560 |                | .550                       | .550  | .551  | .548  |    |      |
| P             | 0.490 | 0.510 |                | .500                       | .500  | .500  | .500  |    |      |
| Q             | 3.715 | 3.725 |                | 3.719                      | 3.720 | 3.718 | 3.720 |    |      |
| R             | 2.470 | 2.510 |                | 2.500                      | 2.500 | 2.500 | 2.500 |    |      |
| S             | 0.240 | 0.270 |                | .251                       | .250  | .251  | .249  |    |      |
| T             | 0.100 | 0.180 |                | .140                       | .140  | .140  | .140  |    |      |
| U             | 1.625 | 1.635 |                | 1.630                      | 1.630 | 1.630 | 1.630 |    |      |
| V             | 1.362 | 1.372 |                | 1.367                      | 1.366 | 1.367 | 1.367 |    |      |
| W             | 0.316 | 0.321 | DT8690         | /                          | /     | /     | /     |    |      |
| X             | 1.125 | 1.145 |                | 1.134                      | 1.136 | 1.134 | 1.136 |    |      |
| Y             | 1.565 | 1.585 | DT8695 A/B     |                            |       |       |       |    |      |
| Z             |       |       |                |                            |       |       |       |    |      |
| AA            |       |       |                |                            |       |       |       |    |      |
| AB            |       |       |                |                            |       |       |       |    |      |
| AC            |       |       |                |                            |       |       |       |    |      |
| AD            |       |       |                |                            |       |       |       |    |      |
| AE            |       |       |                |                            |       |       |       |    |      |
| AF            |       |       |                |                            |       |       |       |    |      |
| AG            |       |       |                |                            |       |       |       |    |      |
| AH            |       |       |                |                            |       |       |       |    |      |
| Accept/Reject |       |       |                |                            |       |       |       |    |      |

|              |          |
|--------------|----------|
| Measured by: | J.L.     |
| Date:        | 06.04.20 |

|             |          |
|-------------|----------|
| Audited by: | En       |
| Date:       | 06/04/21 |

| Rev | Date     | Change   | Revised by | Approved |
|-----|----------|--|------------|----------|
| A   |          | New Issue  | RF         |          |
| B   | 02.12.12 | Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B | KJ/RF      |          |



**D2933-1 LH SADDLE (SHOWN)**  
**D2933-2 RH SADDLE (OPPOSITE)**

MATERIAL: 7075-T7351 (Q0-A-250/12)  
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
 DART QSI 005 4.3  
 BREAK ALL SHARP EDGES 0.010 TO 0.020  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYP 2 PLACES)
- 3 CHAMFER 0.050" x 45°

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 26080

|          |               |  |                               |
|----------|---------------|--|-------------------------------|
| B        |               | 00.05.29                                     | CHANGED GEOMETRY AND MATERIAL |
| A        |               | 99.10.29                                     | NEW ISSUE                     |
| DESIGN   | DRAWN BY      | DART DART AEROSPACE USA, INC.<br>BOLIVIA, TN |                               |
| CHECKED  | APPROVED      | DRAWING NO.<br>D2933                         | REV. B<br>SHEET 1 OF 1        |
| DATE     | TITLE         | SCALE  |                               |
| 00.05.29 | SADDLE INSIDE | 2.3  |                               |

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 DART AEROSPACE USA, INC.

RELEASED  
 CD-05-31

Date: Friday, 4/28/2006 7:11:28 AM

User: Chantal Lavoie

INVENTORY ITEMS PICKED  
FOR SLIP NUMBER 2129

Project No. : N/A  
Customer : Dart Helicopters Services  
Part Number : D29332  
Job Number : 26080

Drawing Number : D2933 REV B  
Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE  
Due Date : / /  
Qty : 4  
Slip # : 2129

|   | Location | Store | Picking | Lot No. | Serial No. | Req'd | Taken       |
|---|----------|-------|---------|---------|------------|-------|-------------|
| 1.0 D6101001<br>7075-T7351 2X6X6.25<br>Available 249.00 | MAIN     |       |         | 24890   |            | 4.00  | 4.0000 Each |